

Work Order ID 90526

90526

Page 1

September-19-12 11:50:45 AM

Item ID: D3849-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plate
 Start Date: 9/19/12 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 10/12/12 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 12-09-20 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3849	D								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3849								
<u>304, 1050</u>	Dwg Rev: <u>8</u>								
	Prog Rev: <u>8</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

⑧

R12-10-2

⑧

R12-10-2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

90526

September-19-12 11:50:45 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/19/12 **Start Qty:** 8.00 ***8***

Cust Item ID:

Required Date: 10/12/12 **Req'd Qty:** 8.00 ***Q***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

QC8- Inspect parts - second check

0.00 $\leq m_f$

120

510

QC

Memo

0.00

Quality Control

130

0.00

130

Brake NC

Memo

0.00

Brake NC

Form as per dwg using DT8179 & DT8155

210

QC5- Inspect part completeness to step on W/O

0.00

210

QC

Memo

0.00

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Work Order ID 90526

90526

Page 3

September-19-12 11:50:45 AM

Item ID: D3849-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Plate

Start Date: 9/19/12

Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/12/12

Req'd Qty: 8.00

8

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

Identify as per dwg & Stock Location: W/A

0.00

220

Packaging

Memo

0.00

Packaging

(8)

MAL

12/10/16

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.00

Quality Control

12/10/17

ME

12-10-16

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

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Picklist Print

September-19-12 11:50:45 AM

Page 1

Work Order ID: 90526

Parent Item: D3849-5

Parent Item Name: Plate

Start Date: 9/19/12

Required Date: 10/12/12

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 12.09.11 AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 304/316 .050 Sheet		Purchased	No			100	sf	148.9849	4	33.684211	36	12-10-12	

Location

Loc Qty

Loc Code

MAT020

148.984947

120604

4.38421

121626

1.65

121660

27.000737

122325

115.95

123155

123155

8

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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DART AEROSPACE LTD		Work Order:	90526
Description: Wearplate		Part Number:	D3849-5
Inspection Dwg: D3849	Rev: <i>PD</i>		Page 1 of 1

12/09/20

FIRST ARTICLE INSPECTION CHECKLIST

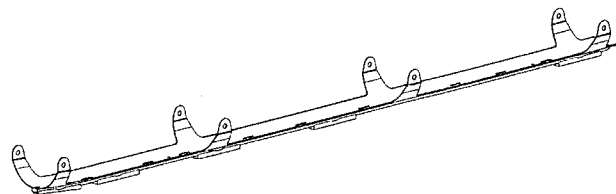
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188 ✓	+0.005/-0.001	.189	2		V RB2	
Ø0.375 ✓	+0.006/-0.001	.378	2		V	
0.125 ✓	+/-0.010	.126	2		V	
0.88 ✓	+/-0.030	.88	2		V	
0.75 ✓	+/-0.030	.757	2		V	
3.283 ✓	+/-0.010	3.280	2		V	
2.433 ✓	+/-0.010	2.440	2		V	
6.642 ✓	+/-0.010	6.639	2		V	
7.72 ✓	+/-0.030	7.714	2		V	
2.45 ✓	+/-0.030	2.45	2		V	
4.00	+/-0.030					
18.712 ✓	+/-0.010	18.712	2		T RB1	
36.622 ✓	+/-0.010	36.622	2		T	
62.788 ✓	+/-0.010	62.788	2		T	
75.261 ✓	+/-0.010	75.261	2		T	
4.38	+/-0.030					
7.00 ✓	+/-0.030	7.00	2		V	
51.00	+/-0.030					
79.76 ✓	+/-0.030	79.76	2		T	
0.050 ✓	+/-0.010	.048	2		V	

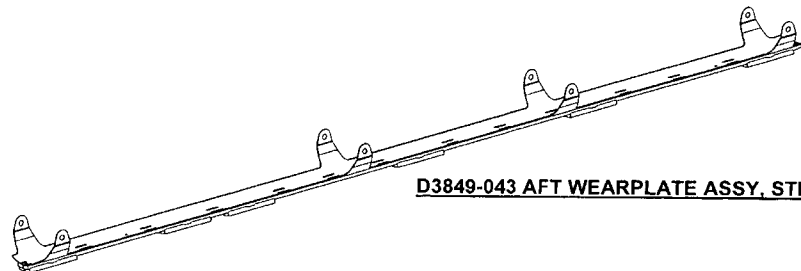
Measured by: <i>RB</i>	Audited by: <i>SmB</i>	Prototype Approval:	N/A
Date: <i>12-10-2</i>	Date: <i>12/10/20</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<i>[Signature]</i>

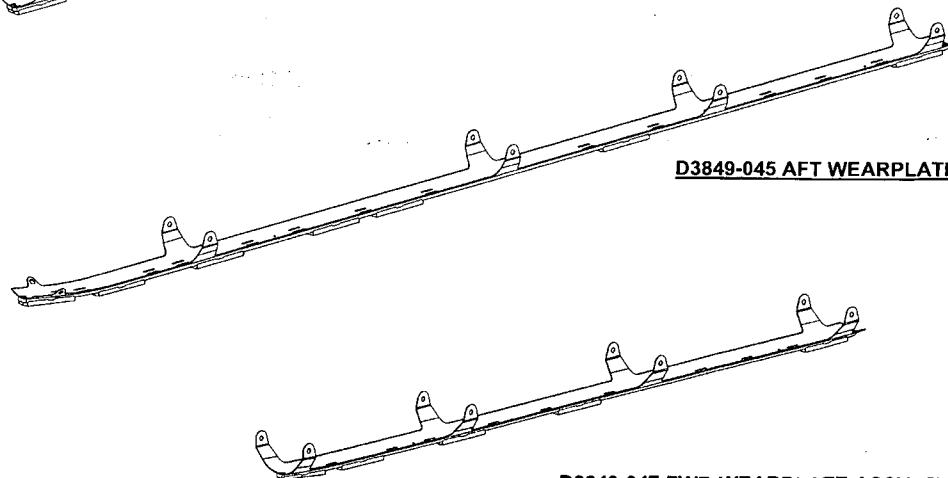
P/O D3849-045



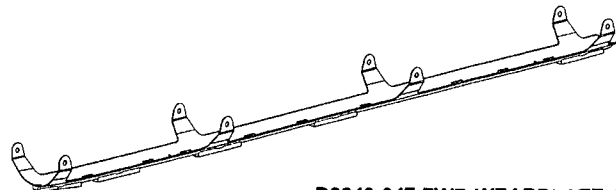
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1			1	D3901-1	BAR
16		2			D3901-3	BAR
17			2		D3901-5	BAR
21	A/R	A/R	A/R	A/R	2059B	HARDCOAT
22	A/R	A/R	A/R	A/R	4714	PLUS ONE ROCKGUARD

SHOP
RETURN
ENGINE
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK
NO. 9.05.26 MLT
12-09-20
RELEASED
2012-09-04

D	REVISED FLAT PATTERN - CHANGED SLOT LOCATIONS TO MATCH D3901-1/3/5 BARS (ZN B6-6, B3-6, B6-7, C2-7, B6-8, B2-8, B7-9, B2-9).	DC	12.08.23
C	REVISED FLAT PATTERN - CHANGE SLOT LOCATIONS. ADDED DOUBLE SLOTS AND D3901-3/5 BARS ON -043/-045. UPDATED DETAIL VIEWS. CHANGED WELD DETAILS (ZN B2-2). REMOVED D3849-1/3/5/7 GASKETS. ADD ROCKGUARD COATING. REMOVE FINISH.	DC	12.08.21
B	REVISED FLAT PATTERN Ø 0.375 WAS SLOT HOLE ON D3849-1/3/5/7 (ZN A4-5, B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.68 & 0.44 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4); 68.87 WAS 67.36 (ZN B4-7).	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	DC		
CHECKED	DC		
MFG. APPR.	DC		
APPROVED	DC		
DE APPR.	DC		
DATE	12.08.23		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D3849

REV. D

SHEET 1 OF 10

TITLE

WEARPLATE ASSY

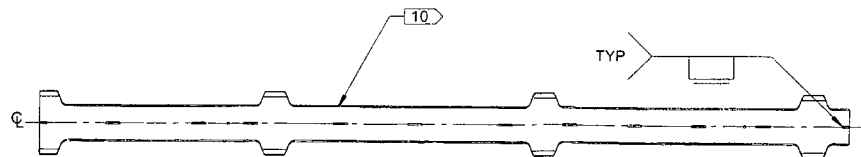
SCALE

NTS

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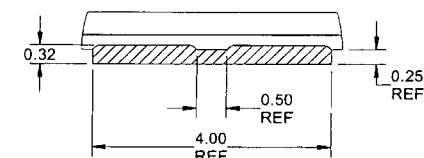
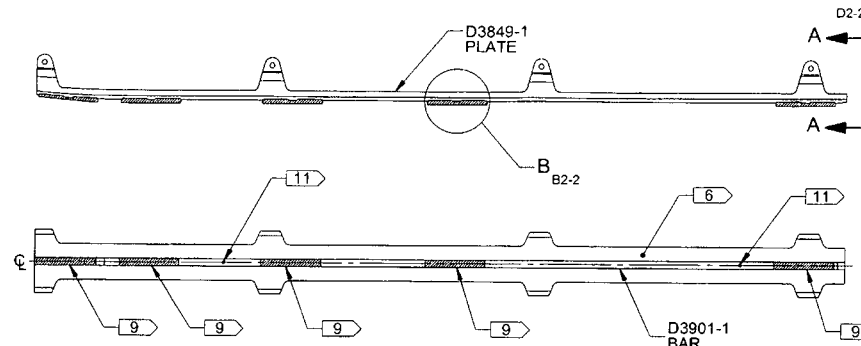
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90526



SECTION A-A

C3-2



DETAIL B

C5-2

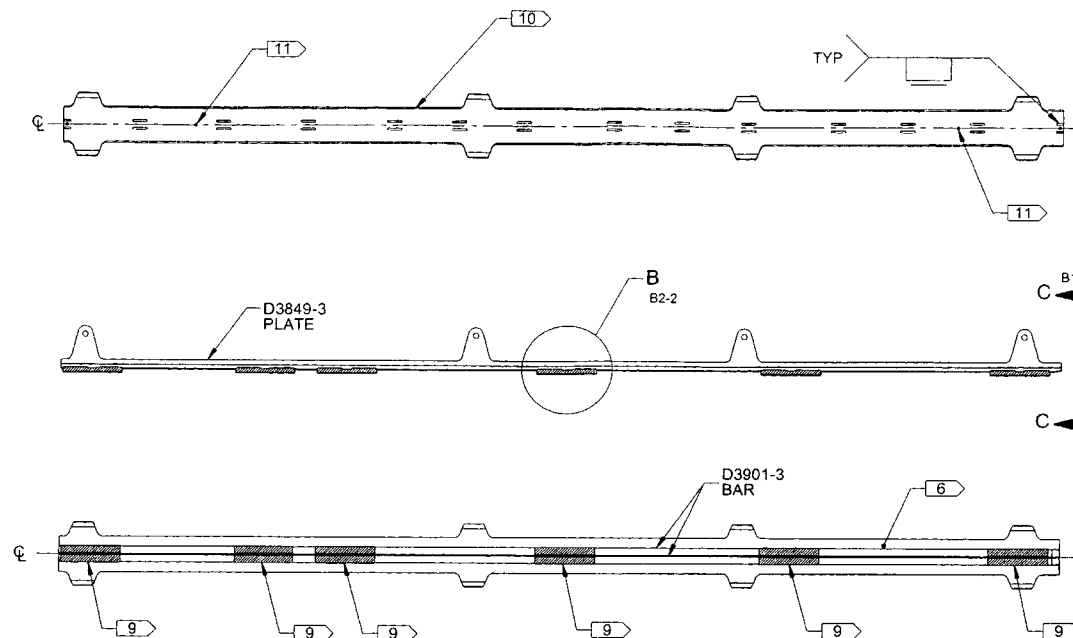
D3849-041 FWD WEARPLATE ASSY, STD/FLOAT GEAR

RELEASED
2012-09-04

NOTES:

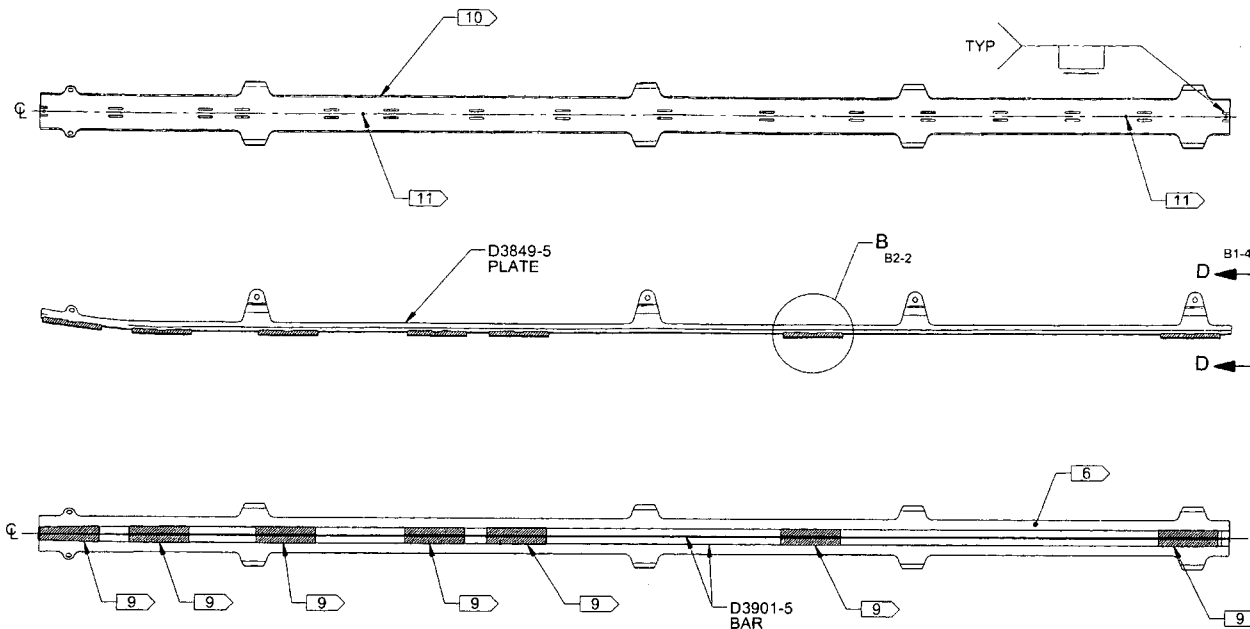
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-041 = 4.58 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL \varnothing 0.188 HOLES FROM D3849-1 PLATE TO D3901-1 BAR

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	RF	D3849	SHEET 2 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
DATE	12.08.23	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

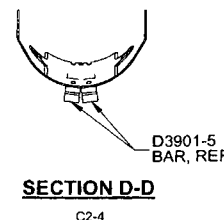


DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	JTC	KENT, WA	REV. D
CHECKED	[Signature]	DRAWING NO. D3849	SHEET 3 OF 10
MFG. APPR.	[Signature]	TITLE WEARPLATE ASSY	SCALE
APPROVED	[Signature]		NTS
DE APPR.	[Signature]		
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90526



D3849-045 AFT WEARPLATE ASSY. FLOAT GEAR



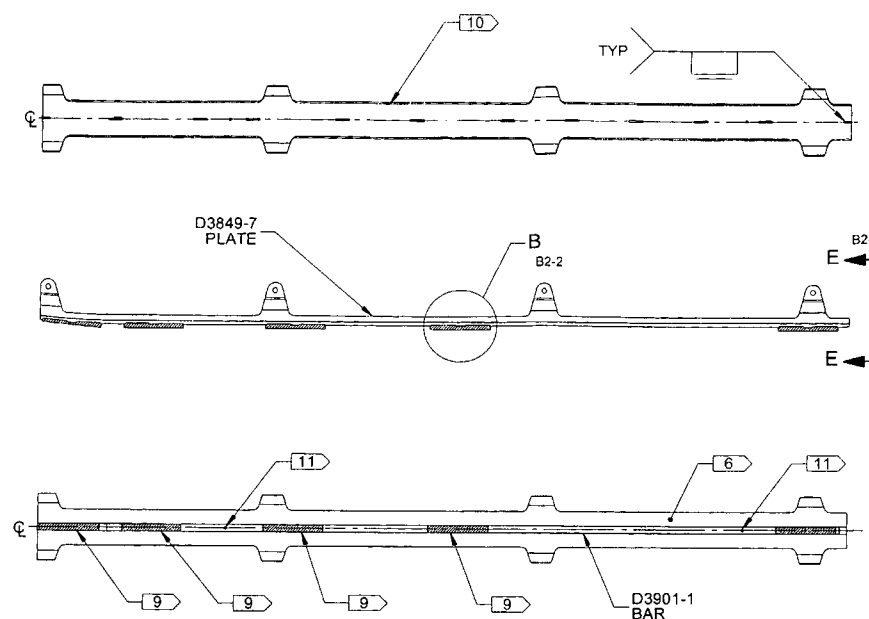
RELEASED
2012-09-04

NOTES:

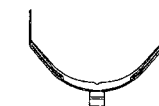
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-045 = 8.93 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BARS ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-5 PLATE TO D3901-5 BARS

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	JLC	KENT, WA	
CHECKED	AB	DRAWING NO.	REV. D
MFG. APPR.	N	D3849	SHEET 4 OF 10
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	WEARPLATE ASSY	NTS
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90526



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR



SECTION E-E

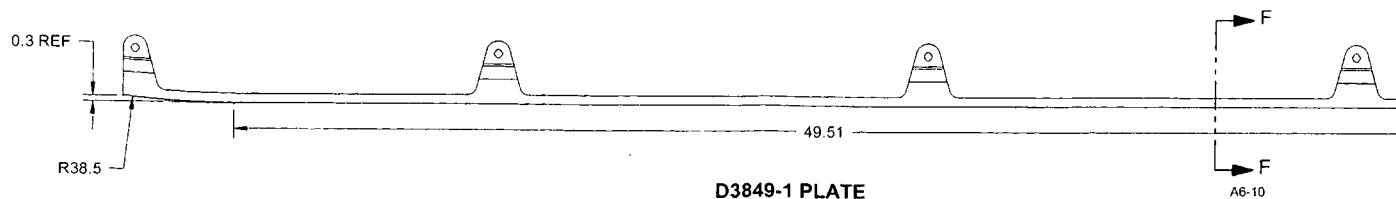
C3-5

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2012-09-04

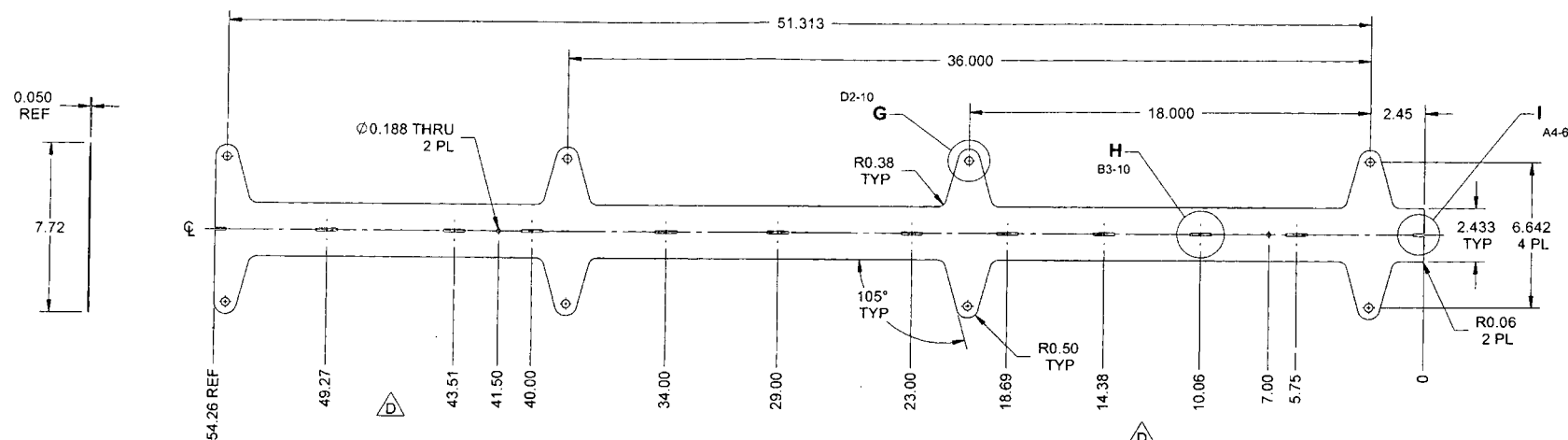
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-047 = 4.60 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL, Ø0.188 HOLES FROM D3849-7 PLATE TO D3901-1 BAR

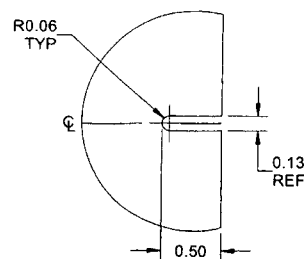
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	PC	KENT, WA	
CHECKED	PC	DRAWING NO.	REV. D
MFG. APPR.	PC	D3849	SHEET 5 OF 10
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	WEARPLATE ASSY	NTS
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D3849-1 PLATE
(MAKE FROM D3849-1F)



D3849-1F FLAT PATTERN



DETAIL I

C2-6
B2-9

NOTES:

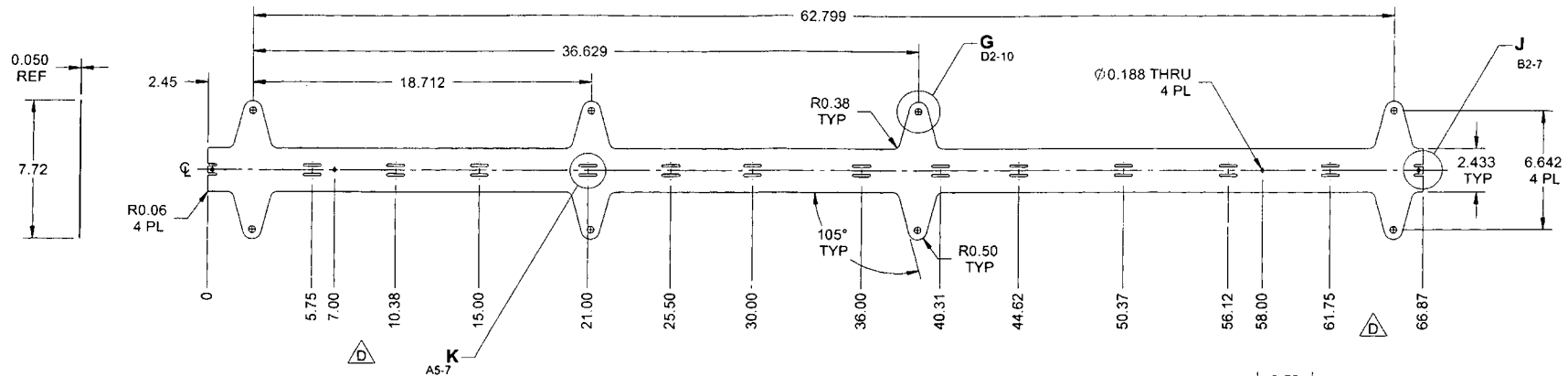
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.30 lbs

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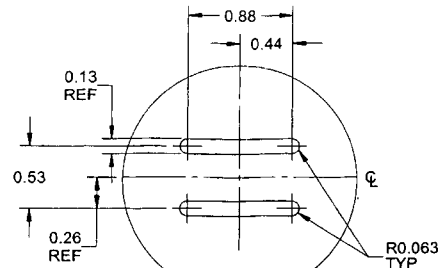
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. D
MFG. APPR.	DC	D3849	SHEET 6 OF 10
APPROVED	DC	TITLE	SCALE
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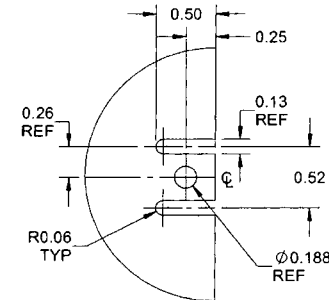
D3849-3 PLATE
(MAKE FROM D3849-3F)



D3849-3F FLAT PATTERN



DETAIL K



DETAIL J

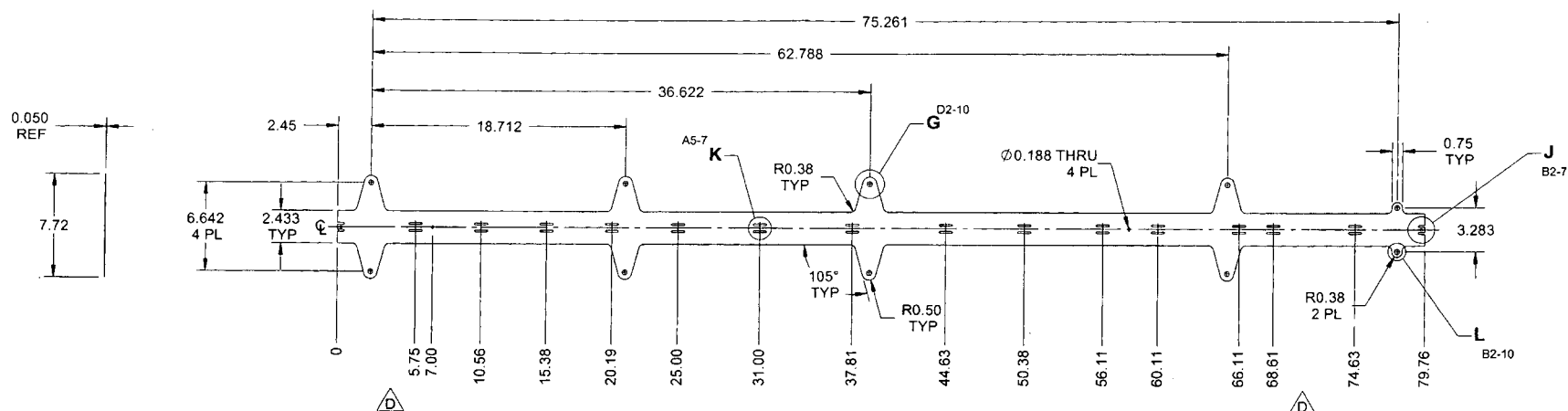
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.74 lbs.

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MFG. APPR.	<i>AS</i>	D3849	SHEET 7 OF 10
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	WEARPLATE ASSY	NTS
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Figure 1 is a schematic diagram of the test specimen. It shows a long, thin specimen with four circular features along its top edge. A force F is applied at the left end, and a dimension of 72.6 is indicated. A reference point is marked as 0.8 REF.

D3849-5 PLATE
(MAKE FROM D3849-5F)



D3849-5F FLAT PATTERN

RELEASED
2012-09-04

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

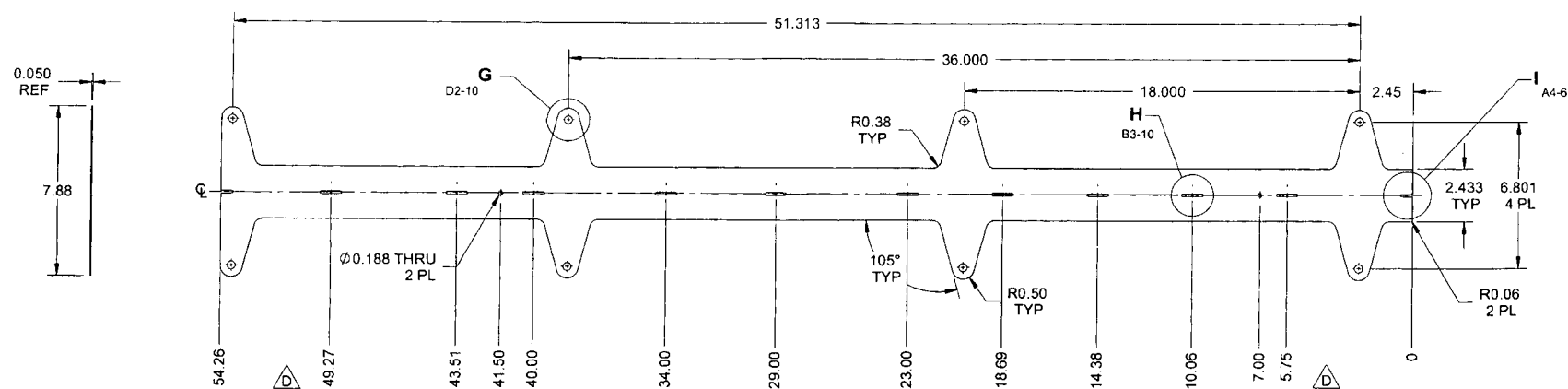
7) WEIGHT: 3.17 lbs

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DRAWN	<i>DFC</i>		SHEET 8 OF 10
CHECKED	<i>DFC</i>		
MFG. APPR.	<i>DFC</i>		SCALE
APPROVED	<i>DFC</i>		NTS
DE APPR.	<i>DFC</i>		
DATE 12.08.23			

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D3849-7 PLATE
(MAKE FROM D3849-7F)



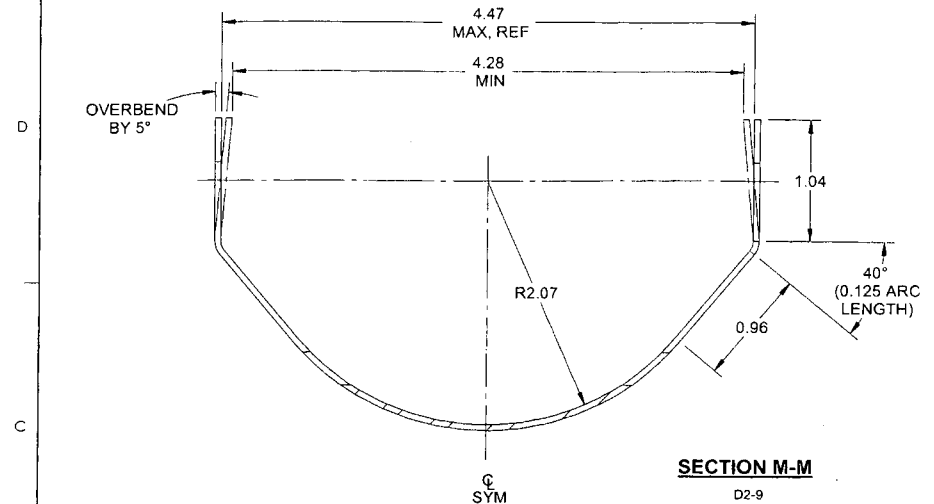
D3849-7F FLAT PATTERN

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2012-09-04
JW

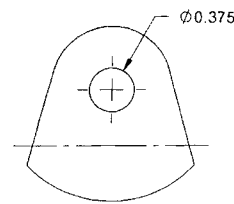
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.32 lbs

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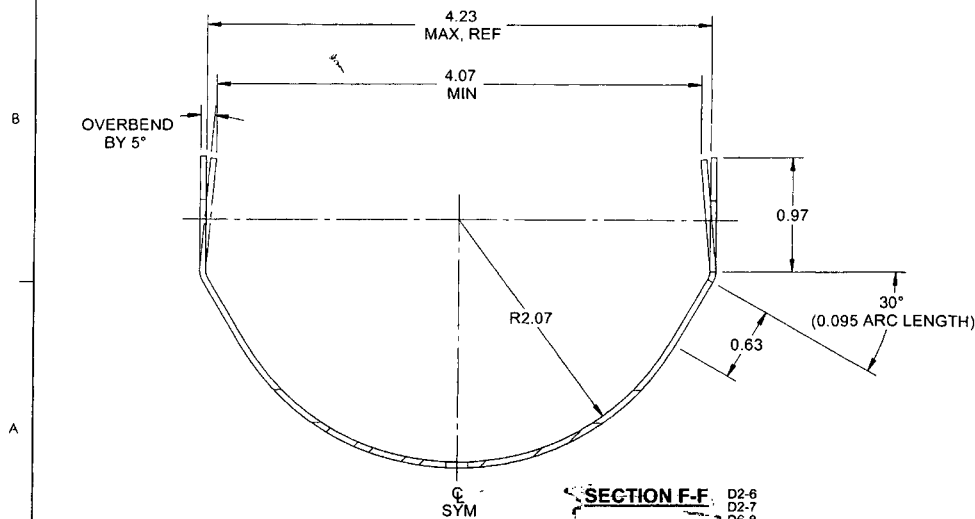
90526



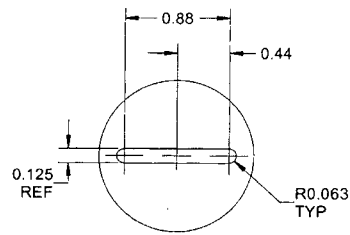
SECTION M-M
D2-9



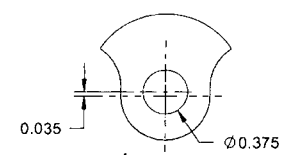
DETAIL G
SLOT DETAIL TYP
C4-6
C4-7
C4-8
C6-9



SECTION F-F
D2-6
D2-7
D6-8



DETAIL H
SLOT DETAIL TYP
C3-6
B3-9



DETAIL L
DETAIL TYP
B2-8

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